

# Work Order ID 130464

March-12-15 10:22:57 AM

**\*130464\***

Page 1

Item ID: D2563

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Step Weldment Assembly

Start Date: 3/12/15 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 3/20/15 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals: Process Plan: W Date:            Tooling:            Date:             
QC:            Date:            SPC (Y/N):            Date:           

Run Start **\*NR1\***

Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr                       | Revision Nbr             |                      |         |        |              |               |               |                  |                |
| D2563                          | Rev C                    |                      |         |        |              |               |               |                  |                |

100

0.00

**\*100\***

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2244 to 89.70" at 34 deg as per dwg D2563

2-Debur ends

3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343

4- Grind

5x DL 15/3/31

APR 08 2015

DAS  
24  
9-89

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*110\***

QC

Memo

0.00

Quality Control

5x DAS 43 APR 08 2015  
7-89



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Item ID: D2563 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Step Weldment Assembly  
 Start Date: 3/12/15 Start Qty: 5.00 **\*5\*** Cust Item ID:  
 Required Date: 3/20/15 Req'd Qty: 5.00 **\*5\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID                | Operation<br>Description                                                                                                                                                                                 | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp                   |
|-----------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------------------------|
| 150<br><b>*150*</b><br>Large Fab<br>Large Fab | Weld per dwg A/R Aluminum rod Batch: <u>128316</u><br>Large Fab<br><br>Memo<br><br>1-Inspect for foreign object per QSI 024<br><br>2-Weld Remainig End cap as per Dwg D2563 using DT 8343<br><br>3-Grind | 0.00<br><br>0.00     |         |        |              | 5             |               | APR 09 2015      | DAS<br>24<br>9-89                |
| 160<br><b>*160*</b><br>QC<br>Quality Control  | QC10- Inspect visual per QSI004- ground welds<br><br>Memo                                                                                                                                                | 0.00<br><br>0.00     |         |        |              | (5)           |               |                  | DAS<br>38<br>9-89<br>APR 09 2015 |
| 170<br><b>*170*</b><br>QC<br>Quality Control  | QC5- Inspect part completeness to step on W/O<br><br>Memo                                                                                                                                                | 0.00<br><br>0.00     |         |        |              | (5)           |               |                  | DAS<br>38<br>9-89                |

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[illegible]

# Work Order ID 130464

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**\*130464\***

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Item ID: D2563 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Step Weldment Assembly  
 Start Date: 3/12/15 Start Qty: 5.00 **\*5\*** Cust Item ID:  
 Required Date: 3/20/15 Req'd Qty: 5.00 **\*5\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                        | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp    |
|--------------------------------|-------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|-------------------|
| 200                            | QC3- Inspect Part Finish                        | 0.00                 |         |        |              |               |               |                  | DAS<br>38<br>9-89 |
| <b>*200*</b>                   |                                                 |                      |         |        |              |               |               |                  |                   |
| QC                             | Memo                                            | 0.00                 |         |        |              | 5             |               |                  | 15-04-13          |
| Quality Control                |                                                 |                      |         |        |              |               |               |                  |                   |
| 210                            | Identify as per dwg & Stock Location: <u>13</u> | 0.00                 |         |        |              |               |               |                  | DAS<br>6<br>9-89  |
| <b>*210*</b>                   |                                                 |                      |         |        |              |               |               |                  |                   |
| Packaging                      | Memo                                            | 0.00                 |         |        |              |               |               |                  | APR 13 2015       |
| Packaging                      |                                                 |                      |         |        |              |               |               |                  |                   |
| 220                            | QC21- Final Inspection - Work Order Release     | 0.00                 |         |        |              |               |               |                  |                   |
| <b>*220*</b>                   |                                                 |                      |         |        |              |               |               |                  |                   |
| QC                             | Memo                                            | 0.00                 |         |        |              |               |               |                  | ML5 15-04-13      |
| Quality Control                |                                                 |                      |         |        |              |               |               |                  |                   |

**15-04-13**

# Picklist Print

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Work Order ID: 130464

**\*130464\***

Parent Item: D2563

**\*D2563\***

Parent Item Name: Step Weldment Assembly

Start Date: 3/12/15

Required Date: 3/20/15

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:G 02.07.31 Re-format Location RF

| Component Item ID/<br>Item Name                   | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status            |
|---------------------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|-------------------|
| D2244-116<br><b>*D2244-116*</b><br>STEP EXTRUSION |                        | Manufactured  | No          |                     |                  | 100             | Each               | 163.0000       | 1           | 5            |               |                | DAS<br>24<br>9-89 |
|                                                   |                        |               |             |                     |                  |                 |                    |                |             | **           | APR 07 2015   |                |                   |

Location Loc Qty Loc Code

HALL 138

117818 138

WA003 24.9999632

104940 25

D2561

Manufactured No

100 Each 23.0000

2

5

10

DAS  
24  
9-89

**\*D2561\***

Lug

\*\*

APR 07 2015

Location Loc Qty Loc Code

WA003 23

124408 3

129516 20

D2564

Manufactured No

100 Each 21.0000

2

3

7

10

DAS  
24  
9-89

**\*D2564\***

Mounting Angle

\*\*

APR 07 2015

Location Loc Qty Loc Code

WA003 21

123106 1

130030 20

D2673-34

Manufactured No

100 Each 50.0000

1

1

9

5

DAS  
24  
9-89

**\*D2673-34\***

End Plate

\*\*

APR 07 2015

Location Loc Qty Loc Code

WA003 50

128133 50

5

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Work Order ID: 130464

**\*130464\***

Parent Item: D2563

**\*D2563\***

Parent Item Name: Step Weldment Assembly

Start Date: 3/12/15

Required Date: 3/20/15

Start Qty: 5.00

Required Qty: 5.00

D2673-34

Manufactured No

150

Each

50.0000

1

5

**\*D2673-34\***

End Plate

**\*\***

**APR 09 2015**

**DAS  
24  
9-89**

Location

Loc Qty

Loc Code

WA003

50

128133

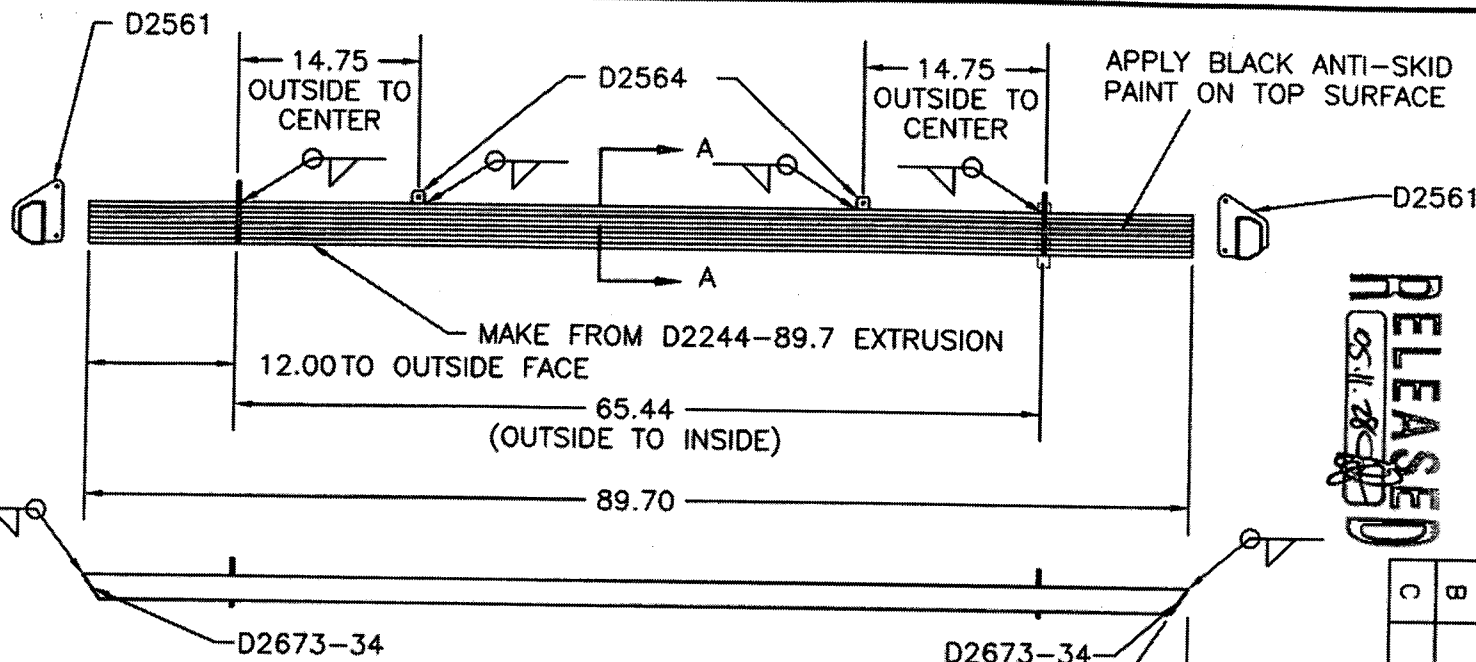
50

5



RELEASED  
05.11.28

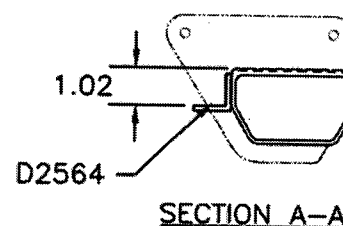
|         |          |                              |                        |                             |
|---------|----------|------------------------------|------------------------|-----------------------------|
| DESIGN  | BW       | DRAWN BY                     | #4                     | DART AEROSPACE LTD          |
| CHECKED | #4       | APPROVED                     | #4                     | DART AEROSPACE LTD          |
| DATE    | 05.11.14 | DRAWING NO.                  | D2563                  | HAWKESBURY, ONTARIO, CANADA |
|         |          | TITLE                        | STEP WELDMENT ASSEMBLY | REV. C                      |
|         |          | SCALE                        | 1:15                   | SHEET 1 OF 1                |
| A       | 96.04.26 | NEW ISSUE                    |                        |                             |
| B       | 97.05.14 | END CAPS CHANGED (WAS D2248) |                        |                             |
| C       | 05.11.14 | UPDATE NOTES                 |                        |                             |



#### D2563 STEP WELDMENT ASSEMBLY PARTS LIST

| Part No.   | Description            | QTY |
|------------|------------------------|-----|
| D2563      | STEP WELDMENT ASSEMBLY | X   |
| D2244-89.7 | EXTRUSION*             | 1   |
| D2561      | LUG PLATE              | 2   |
| D2564      | MOUNTING ANGLE         | 2   |

\*cut per drawing



#### D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE  
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED